

Rush

Work Order ID 87153

July 18, 2012 11:21:45 AM

87153

Page 1

Item ID: D350-588-041

Revision ID:

Item Name: Aft Door Assembly

Start Date: 7/10/12 Start Qty: 1.00 *1*

Required Date: 8/03/12 Req'd Qty: 1.00 *1*

Reference:

Approvals: Process Plan: CL Date: 12/07/18 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

0.00

15
12/11/14

MCJ 12-11-13

110

0.00

110

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 17478
Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

0.00

CL 12/07/18 ①

DA
11
8-8

500

AS

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																								
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 87153

87153

Page 2

July 18, 2012 11:21:45 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 7/10/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

DAS
16
9-89

12/11/13

DAS
11
89

12.11.13

12-11-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 87153

87153

Page 3

July 18, 2012 11:21:45 AM

Item ID: D350-588-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 7/10/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
155	Pick Kit	0.00							
155									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS 16 2-83 12/11/13

12/11/14 JB

DAS 15 2-83 12/11/14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 87153***87153***

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July 18, 2012 11:21:45 AM

Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 7/10/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

1.2 6/11/14 SP

MLJ 12-11-14

mf
12-11-14

Picklist Print

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Page 1

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as per DSI9414 DD
verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P		Purchased	No			110	Each	0.0000	1	1	87653	u	
AFT DOOR ASSEMBLY													
AN526G832R9		Purchased	No			140	Each	382.0000	8	8	m/228148p		
Screw													

Location Loc Qty Loc Code

ST346 373

120181 21

121556 152

122151 200

ST347 9

118983 9

140 Each 0.0000

140 Each 29.0000

Location Loc Qty Loc Code

ST -28

76100 10

ST004 19

82335 19

ST198 38

140 Each 7.0000

Location Loc Qty Loc Code

ST005 7

78993 7

AN960JD10

Washer

D2143

Hinge Bracket

D2143

Hinge Bracket

NA511910332T

NA511910332T

11

11

2 2 8p m/22973

1 1 8p

1x B860879
B840708p

12-11-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Page 2

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2463 Manufactured No

Seal

Curc 5704
Qty = 1 Sng

Location	Loc Qty	Loc Code
ST404	479.31737	
72232	15.38	
79478	0.43737	
83542	463.5	

140

f

479.3174

7.25

7.25

SP

D2555 Manufactured No

Mounting Channel

Location	Loc Qty	Loc Code
ST011	72	
73297	2	
82029	20	
83369	6	
85425	44	

140

Each

72.0000

7.25
2

B89387 SP

D2586 Manufactured No

Door Latch

Location	Loc Qty	Loc Code
ST203A	100	
78833	1	
83893	99	

140

Each

100.0000

2

B89150 SP

D2621 Manufactured No

Latch Plate, 350 Spacepod

Location	Loc Qty	Loc Code
ST013	31	
78991	19	
86368	12	

140

Each

31.0000

2

SP

D2857-1 Manufactured No

Hinge Bracket

Location	Loc Qty	Loc Code
ST019	28	
75253	4	
82261	24	

140

Each

28.0000

1

2x
SP 12-11-13

July 18, 2012 11:21:44 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

~~D28572~~
Hinge Bracket

Manufactured No

140 Each 16.0000



B915448P

MS21042L08
Nut

Purchased No

Location

Loc Qty

Loc Code

ST019 16
78904 16

140 Each 833.0000

8 8

SP

Location

Loc Qty

Loc Code

ST300 33
121524 33
ST317 800
122141 800

140 Each 3,107.0000

2 2

SP

M123265 SP

MS21042L3
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300 1107
117885 32
119017 757
119075 138
121444 180
ST317 2000
122141 2000

140 Each 31.0000

2

M123352

SP 12-11-13

MS27039-1-15
Screw

Purchased No

Location

Loc Qty

Loc Code

ST291 31
118574 2
119736 1
121243 28

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Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 4

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

140

Each

409.0000

8

8

WASHER

M 122441 SP

Location

Loc Qty

Loc Code

ST298

409

119717

41

120422

368

AN526G1032R7

Purchased

No

155

Each

70.0000

2

2

Screw

20

SMD

Location

Loc Qty

Loc Code

ST348

70

116304

10

119449

60

AN526G832R8

Purchased

No

155

Each

127.0000

8

8

Screw

119449

122814

20

SMD

Location

Loc Qty

Loc Code

ST346

115

120717

15

122151

100

ST347

12

116410

3

116471

5

118926

4

AN960JD10

Washer

D2150

Packer Doubler, Hinge

NAS1149D0363J

Purchased

No

155

Each

0.0000

2

2

123248

86883

20

12/11/14

Manufactured

No

155

Each

36.0000

2

2

Location

Loc Qty

Loc Code

ST005

36

82136

16

85513

20

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Shop Packet Print

Page 4

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____

Picklist Print

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Page 5

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2151
Packer Doubler, Hinge

Manufactured No

155 Each 40.0000

2 2 ✓ *20*



Location

Loc Qty

Loc Code

ST005

40

82137

20

85514

20

85514

Sm

D2153
Door Prop

Manufactured No

155 Each 52.0000

1 1 ✓ *20*



Location

Loc Qty

Loc Code

ST272

52

78369

16

85865

36

85865

D2154
Stud Bracket

Manufactured No

155 Each 60.0000

1 1 ✓ *20*



Location

Loc Qty

Loc Code

ST005

60

64312

1

77024

3

82333

56

82333

D2237
Striker Plate

Manufactured No

155 Each 62.0000

2 *89925* ✓ *20* *12/11/14*



Location

Loc Qty

Loc Code

ST006

42

64426

2

66139

1

82062

3

83376

36

ST009

20

85476

20

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Page 5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Picklist Print

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Page 6

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2461
Neoprene "D" Seal

Manufactured No

155 f 684.4367

7.25

7.25

7.25



Location

Loc Qty

Loc Code

ST402

184.43684

39782

6.5

55054

4

63880

14.8237

73644

159.112984

ST402A

500

85225

500

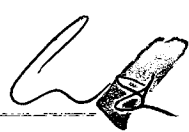
73644

Manufactured No

155 Each 0.0000



58194



D2589
Keys, Key Chain, 350 Hinge

D269017
Cable

Manufactured No

155 Each 31.0000



1

1



Location

Loc Qty

Loc Code

ST016

31

64786

1

66510

1

84069

19

85866

6

86649

4

85866

Manufactured No

155 Each 37.0000



1

7.25

12/11/13



D2858-1
Hinge Bracket

Location

Loc Qty

Loc Code

ST019

37

63695

1

77019

12

82337

24

82337

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Page 6

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 7

Work Order ID: 87153
Parent Item: D350-588-041
Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D2858-2 Manufactured No 155 Each 32.0000

Hinge Bracket

1 1 JB

Location Loc Qty Loc Code

ST019 32
64787 1
77020 8
82336 23

Sm

PG-778150-550-ROE
7781 9oz Glass 50"x125yd

Purchased No 155 sf 2,764.4910

82336 123239 JB

Location Loc Qty Loc Code

CA 2764.491
104845 3
108932 18
111166 392
113905 564
117602 664.651
119099 1122.84

Sm

MS20426AD3-4
RIVE1

Purchased No 155 Each 2,552.0000

12 123021 12 JB

Location Loc Qty Loc Code

ST316 2552
104374 236
110398 2316

Sm

MS20470AD4-5
Rivet, Universal Head

Purchased No 155 Each 1,136.0000

18 122452 18 JB 12/11/13

Location Loc Qty Loc Code

ST319 1136
118405 389
120142 747

Sm

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Page 7

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---

Picklist Print

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Page 8

Work Order ID: 87153

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

MS210421U08
Nut

Purchased No

155 Each 833.0000

10 10

Location Loc Qty Loc Code

ST300 33

121524 33

ST317 800

122141 800

MS210421L3
Nut

Purchased No

155 Each 3,107.0000

4 4

Location Loc Qty Loc Code

ST300 1107

117885 32

119017 757

119075 138

121444 180

ST317 2000

122141 2000

MS27039-08-11
Screw

Purchased No

155 Each 59.0000

2 2

Location Loc Qty Loc Code

ST290 7

117441 7

ST292 52

116289 2

120833 50

NASH149DN832J
WASHER

Purchased No

155 Each 409.0000

16 16

Location Loc Qty Loc Code

ST298 409

119717 41

120422 368

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Shop Packet Print

Page 8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

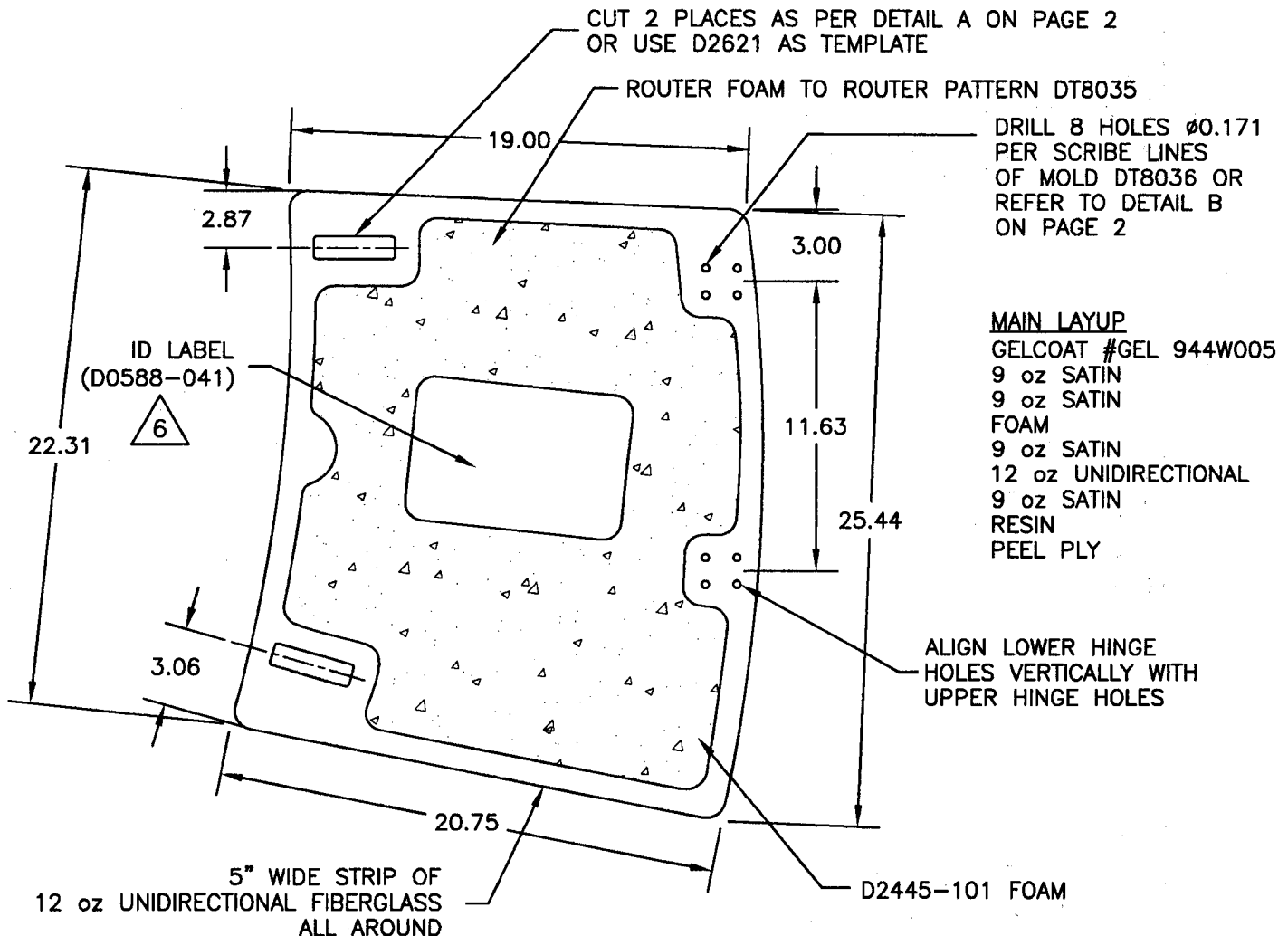
Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13 *[Signature]*



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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87153

12-07-12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

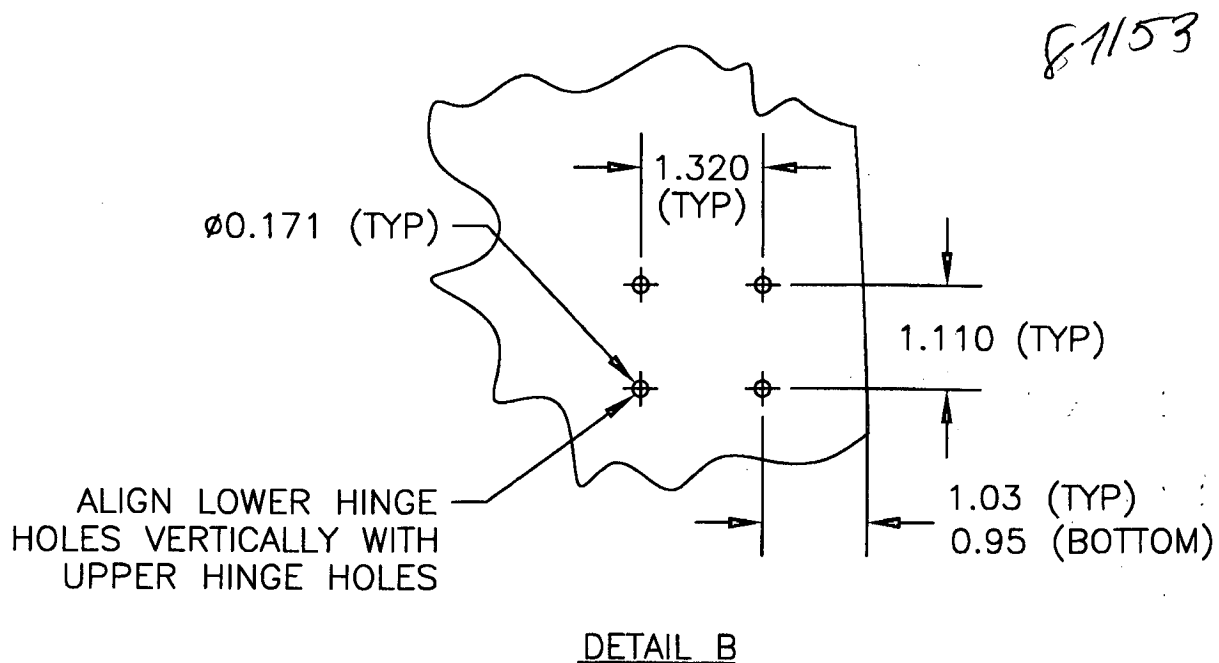
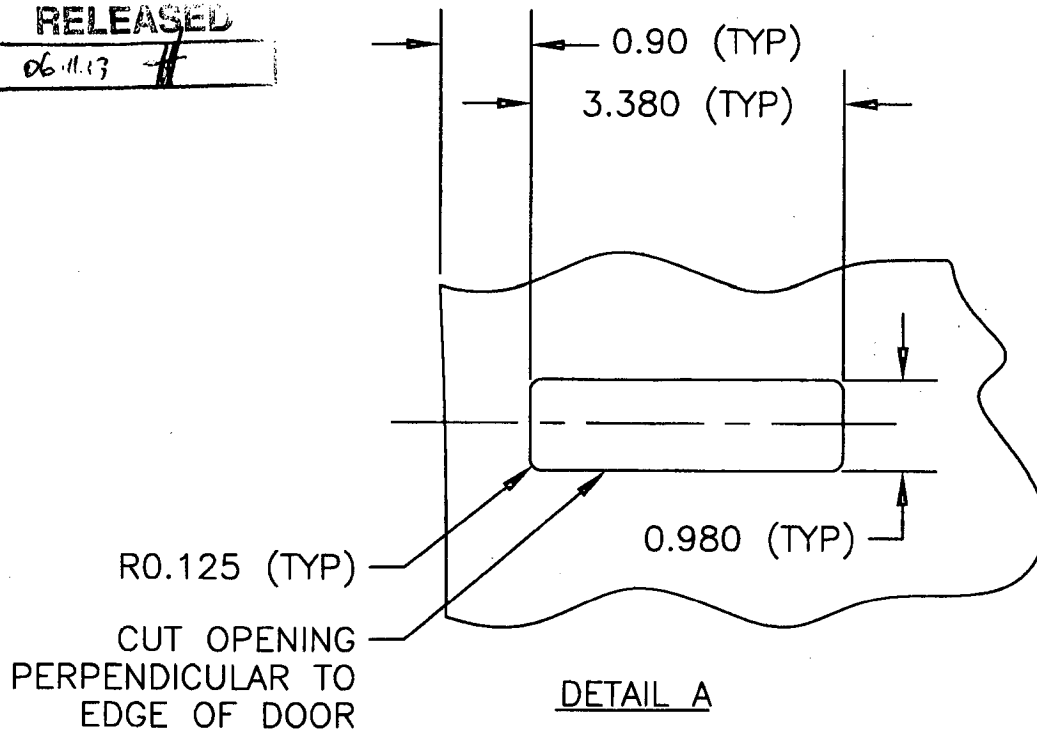
Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge _____ _____ _____	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED
06.11.13 *[Signature]*



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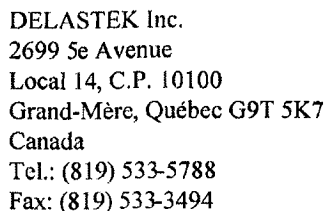
NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		



Invoice No.	44870.
Customer No.	DART US

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AO-357

☐ Cust. ☐ Adm. ☐ Quality ☒ Ship.

DELASTEK AERONAUTIQUE



Date: Mardi, 2012-07-24 09:04:48
Utilisateur: marc dubé

Feuille de Procédé

18 Août

Client : DART US DART AEROSPACE	Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Job : 43209	Numéro Article : DKC134-0013
Numéro : 3959	Numéro Dessin : D2445
Numéro B.A. :	Projet Numéro : DK-362
Cette fois : 2012-07-24 No. :	Révision dessin : D
Prsht Rev. : NC	Matériel : Composite
Prem. fois : - - - Type :	Date Dûe : 2012-09-05
Job précédente : 39934	Qté: 1 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D2445

Process Sheet Rév.: 02 AAC1885 était AC0883,
AAC1887 était AC0884, # de projet était DK-134.

B 87153

Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Comment Qty.: 0.200 UNITE(s)/Unit Total: 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-33/83-1

2.0	PREP-GENERAL	Préparation du matériel ✓
-----	--------------	---------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule N° DT-8028 selon IG 0009.

Date: 15/08/12

Sceau:



3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-34801-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Comment Qty.: 0.0320 GALLON(s)/Unit Total: 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 15/08/12







Sceau:



Date: Mardi, 2012-07-24 09:04:48

Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	43209	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	GEL COAT	Application du Gel Coat	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire l'application du Gelcoat selon IG 0019		
Date:	15/08/12	Sceau:	
7.0	AAC1885	Tissu à délaminer Release ply B	
Comment	Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)		
	Tissu à délaminer Release ply B # de Lot: N/A 15/08/12		
8.0	AAC1887	Wrightlon 5200 Bleu P3	
Comment	Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)		
	Wrightlon 5200 Bleu P3 # de Lot: N/A 15/08/12		
9.0	AC0885	Feutre de drainage N° Airweave N 10	
Comment	Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)		
10.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment	Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)		
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment	Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)		
	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-36539-2		
12.0	AMB0349	Fiberglass 12 oz Unidirectional	
Comment	Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)		
	Fiberglass 12 oz Unidirectional N° de Lot: 1-22547-1		
13.0	AC0886	Ruban à gommer jaune # T/AT-200Y	
Comment	Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)		
14.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Tailler le matériel, selon les différents patrons de découpe comme suit:		
	4 plis de tissus de 9.7 oz.		
	1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.		
	3 fois le sac à vide Stretchlon 200.		
	3 fois le film perforé P-3		
	3 fois le feutre de drainage		
	2 fois le tissu à délaminer (non nécessaire lors du bagging du core).		
	Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.		

Date: Mardi, 2012-07-24 09:04:48

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 43209

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 14/08/12

Scellé:



15.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-3856-2

17.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 15/08/12

Scellé:



18.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

A l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 15/08/12

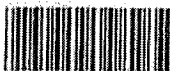
Scellé:



19.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 2:45

Heure Curing Fin: 8:00














Date: 15/08/12

Scellé:



Date: Mardi, 2012-07-24 09:04:48
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	43209	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-36856-2</u>		
22.0	PREP-GENERAL	Préparation du matériel <input checked="" type="checkbox"/>	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>17-11-12</u> Sceau: 		
23.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-29934-1</u>		
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>43657</u>		
25.0	ASSEMBLAGE	Assemblage mécanique <input checked="" type="checkbox"/>	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Assembler le DKC134-0029 selon IG 0033 Date: <u>20/11/12</u> Sceau:  		
26.0	BAGGING	Faire le bagging sur la pièce	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>8:30</u> Heure Fin Curing: _____ Date: <u>20/11/12</u> Sceau:   		

Date: Mardi, 2012-07-24 09:04:48
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 43209

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description:

27.0 AMB0286 Catalyst N° DDM-9
Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.
Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-36256-2

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst
N° DDM-9 par quantité de résine N° 411-350.

Date: 2/10/12

Sceau:



30.0 LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que
les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 2/10/12

Sceau:



31.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 11:00 Heure Curing Fin: 8:00












Date: 2/10/12

Sceau:









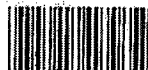








Date: Mardi, 2012-07-24 09:04:48
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	43209	Numéro	DKC134-0013
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
32.0	DÉMOULAGE	Démoulage de la pièce	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Démouler la pièce en faisant bien attention aux coins & Edges.			
Date: <u>22/08/12</u> Sceau: 			
33.0	TRIMAGE	Trimage	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Percer les " Latch " et les trous de pontage selon le dessin N° D2445.			
Date: <u>27/08/12</u> Sceau:  			
34.0	AAC1605	Label N° D0588-041	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Label N° D0588-041 N° de Lot: <u>37008</u>			
35.0	AAC1609	Surface Veil	
Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s) Surface Veil N° de Lot: <u>N/A</u>			
36.0	AAC1220	Résine Mia-Poxy 100	
Comment Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s) Résine Mia-Poxy 100 N° de Lot: <u>1-25679-1</u>			
37.0	AAC1221	Durcisseur 95 Pour Résine Mia-Poxy	
Comment Qty.: 0.007 QUART(s)/Unit Total : 0.007 QUART(s) Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: <u>1-30095-3</u>			
38.0	ASSEMBLAGE	Assemblage mécanique	
 			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Coller le label N° D0588-041 selon IG 0111.			
Date: <u>30/08/12</u> Sceau: 			

Date: Mardi, 2012-07-24 09:04:48
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	N° D2445, AFT BAGGAGE DOOR
Numéro Job:	43209	Numéro	DKC134-0013
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
39.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.014 GALLON(s)/Unit Total: 0.014 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-36797-1		
40.0	FINITION	Finition Générale	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3. Date: 31/07/12 Sceau:  		
41.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-34195-2		
42.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-34636-5		
43.0	PRIMER	Application primer	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation et l'application du primer selon I.G. 0008 Date: 1 Sceau:  # de fiche de mélange: N/A  premier primer 29-08-12 Lot premier: 1-34195-2 Lot activator: 1-33616-2		
44.0	INSPEC FINAL	Inspection finale	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire l'inspection selon le dessin N° D2445. Date: 6 sept 12 Sceau: 		
45.0	EMBAL / ENTREPO	Emballage & Entreposage	
	 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire l'emballage des pièces selon I.G. 0057. Date: 1 Sceau: 		

REFERENCE ONLY *SM*

DART AEROSPACE LTD.

ICA-D350-588

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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

<i>588-041</i> <i>(X)</i>	588-011	Part Number	Description
		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
<i>0</i>	1	D2143	HINGE DOUBLER
<i>1</i>	1	D2144	HINGE DOUBLER
<i>0</i>	2	D2150	HINGE PACKER
<i>0</i>	2	D2151	HINGE DOUBLER
<i>0</i>	1	D2153-3315-10	GAS SPRING ASSY.
<i>0</i>	1	D2154	STUD BRACKET
<i>0</i>	2	D2237	STRIKER PLATE
<i>0</i>		D2445	DOOR
<i>0</i>	1	D2461-0870	NEOPRENE D SEAL
<i>0</i>	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
<i>0</i>	2	D2585	LATCH CLAMP
<i>2</i>	2	D2586	LATCH
	1	D2587	PLUG
<i>0</i>	1	D2589	KEYS, KEY CHAIN
<i>0</i>		D2621	LATCH PLATE
<i>0</i>	1	D2690-17	CABLE, DOOR STOP
<i>0</i>	1	D2857-1	LOWER HINGE BRACKET
<i>0</i>	1	D2857-2	UPPER HINGE BRACKET
<i>0</i>	1	D2858-1	LOWER HINGE BRACKET
<i>0</i>	1	D2858-2	UPPER HINGE BRACKET
<i>0</i>	8	AN526C832R8	SCREW (or AN526-832R8)
<i>0</i>	8	AN526C832R9	SCREW (or AN526-832R9)
<i>0</i>	2	AN526C1032R7	SCREW (or AN526-1032R7)
<i>0</i>	24	AN960JD8	WASHER -16
<i>0</i>	4	AN960JD10	WASHER
<i>0</i>	12	MS20426AD3-4	RIVET
<i>0</i>	18	MS20470AD4-5	RIVET
<i>0</i>	18	MS21042L08	NUT (or MS21042-08) -10
<i>0</i>	4	MS21042L3	NUT (or MS21042-3)
<i>0</i>	2	MS27039-1-15	SCREW
<i>0</i>	2	MS27039-0811	SCREW
<i>0</i>	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

Revision: 0

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